












Thursday, 5/10/2007 2:26:00 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: REPLACEMENT WINDOW ASSEMBLY
Job Number	: 32285		
Estimate Number	: 11174		
P.O. Number	: <u>N/A</u>	Part Number	: D3290041
This Issue	: 5/10/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3290 REV B
Prsht Rev.	: NC	Project Number	: N/A
First issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28649	Material	: <u>N/A</u>
Written By	: <u>JA</u>	Due Date	: 6/6/2007 Qty: 6 Um: Each
Checked & Approved By	: <u>JA 07.05.10</u>		
Comment	: Est. B 05.05.25 Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798 EC Est Rev:D Now on Waterjet 06-06-16 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S040	5052-H32 .040 Sheet	
			
Comment: Qty.: 3.9375 sf(s)/Unit Total : 23.6250 sf(s) 5052-H32 .040 Sheet (M5052H32S040) Batch: <u>M101875 (3)⁺ M102723 (3)</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3290 Dwg Rev: <u>B</u> Prog Rev: <u>B</u>			
2-Deburr if necessary <u>m107/06/26 x6 1</u> <u>SAO</u> <u>07/06/13</u> <u>6</u> <u>(PTD)</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAO</u> <u>07/06/13</u> <u>6</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>SAO</u> <u>07/06/13</u> <u>x6</u>			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>SAO</u> <u>07-06-27</u> <u>x6</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3290-041 PAR #: JLA Fault Category: Prod Eng: ASS: med & small NCR: Yes No DQA: 12 Date: 07/07/13
 QA: N/C Closed: 12 Date: 07.07.23

NCR: <u>32285</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/06/13</u>	<u>2.0</u>	<u>One part was Scrap because the jet offset had to be change to 0.017 instead of the regular Offset of 0.015</u>	<u>AS/042</u>	<u>Scrap, destroy, replace</u>	<u>SAD</u> <u>07/06/13</u>	<u>En</u> <u>07/06/18</u>	<u>AS/042</u>	<u>50</u> <u>07/06/18</u>

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:26:00 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 32285

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M1104144



(6x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 07/06/30

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 07/07/13

(6)

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total : 39.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description Batch

1 D2126-0780 Locking Seal

D32619

9.0

D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description Batch

1 D3290-1 Window Frame

B32285

10.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch

1 D3290-3 Window

D32366

E/S 07/07/03 (6)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD 07/07/13

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/13x6

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

En 07/07/14x6

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.16

Job Completion



07.07.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

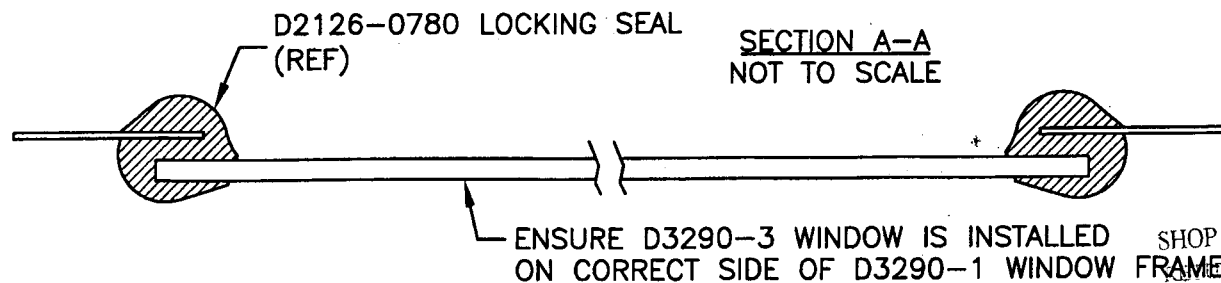
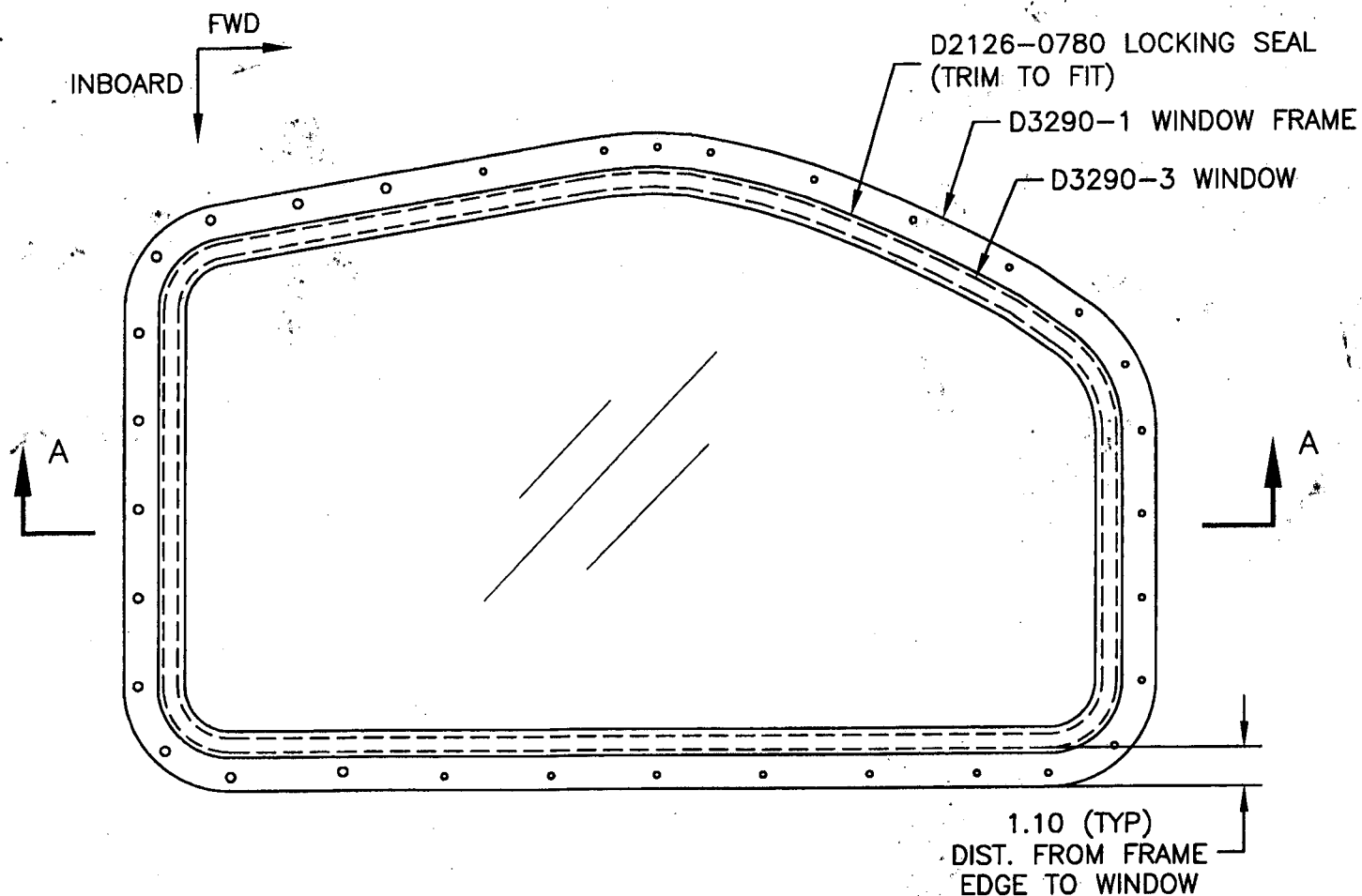
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 1 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
A	04.06.14	NEW ISSUE	
B	06.04.20	UPDATE MATERIAL PER NCR 029	

**D3290-041****NOTES**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

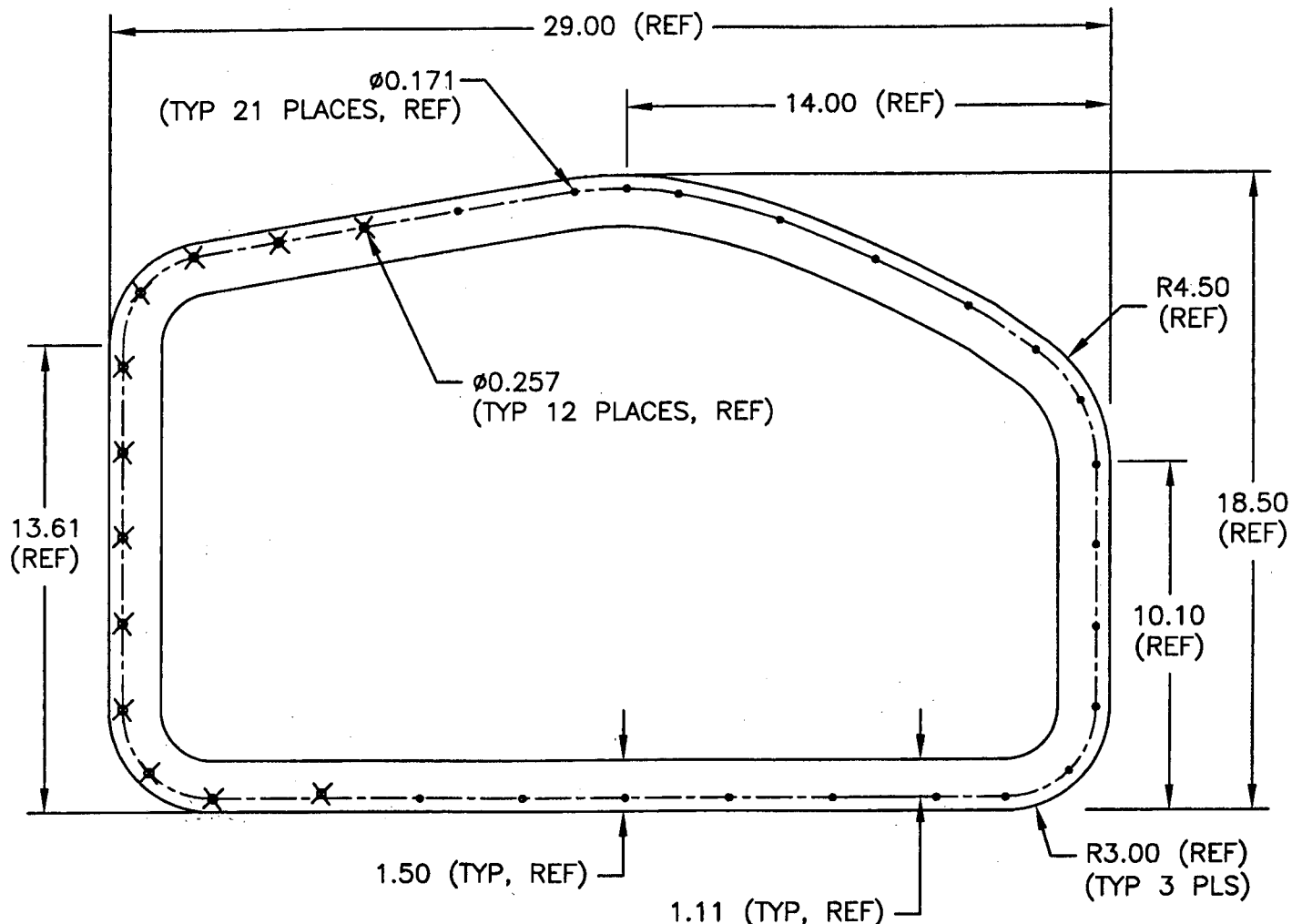
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DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5



D3290-1 FRAME

D3290-1

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.04.20 *[Signature]* COPY
RETURN TO

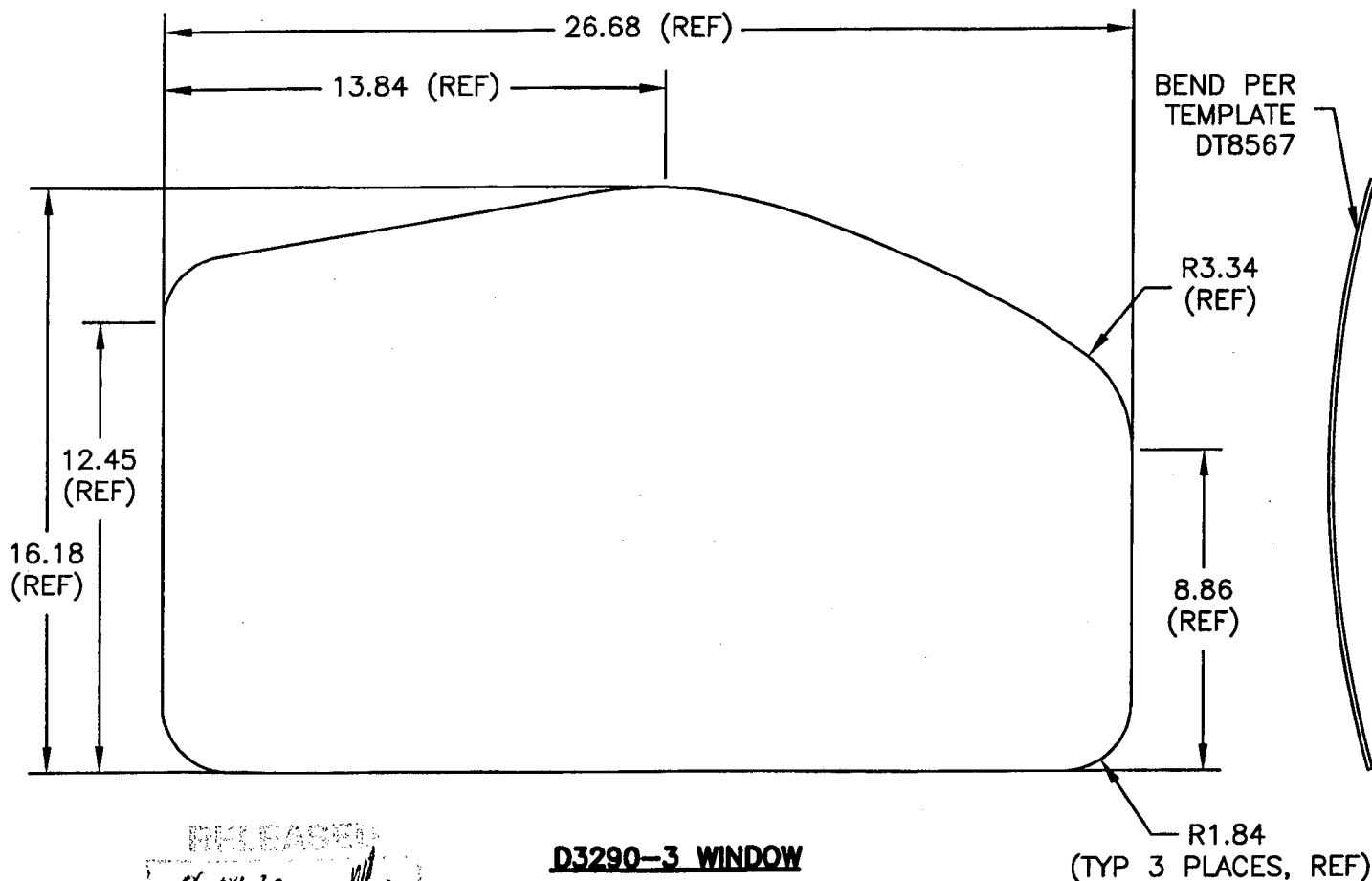
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 3 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5



D3290-3



- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) CHECK PART USING DT3290-3T1

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